

Date: Wednesday, 6/7/2006 11:12:44 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR ASSEMBLY
 Job Number : 27446
 Estimate Number : 12357
 P.O. Number : N/A Part Number : D41269404
 This Issue : 6/7/2006 S.O. No. : N/A Drawing Number : D412-694
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C1
 Previous Run : 27340D Material : N/A Due Date : 6/16/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 05.12.09 New Issue KJ/RF
 Est. Rev B New dwg rev. ecn781 06.04.18 EC

Additional Product

PO 2008860

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-04. CHG005

2.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-04 Drill Process

1- Drill pilot holes Ø(#30) using drill Jig D3144-T10 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T11/T-12 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference.

✓ 2- Drill Pilot holes Ø(#30) using drill Jig D3120-4T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3.

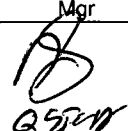
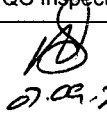
✓ 3- Drill Pilot holes Ø(#30) using drill Jig DT8703-10 for hinges, top cover and D3113-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM).

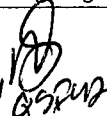
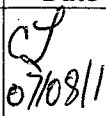
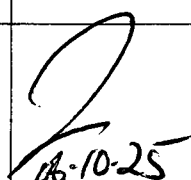
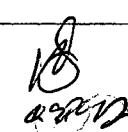
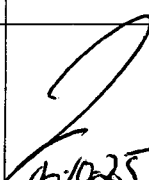
4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-11. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.)

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-12. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF).

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom.

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert top and bottom. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA).

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
01/09/24	2	The fig DT 3144-T10 do not exist. used drawing for holes.	ml	07/09/24		 Q9211	 07.09.24

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-10-25	20	Form was found to be installed upside down, at the lock mechanism location, Result thing in not being able to install lock, R.C. Delisted	 Q9211	See NCR 085. Have Delists lock replace the cover. D3140-08	 07/08/14	 06-10-25	 Q9211	 06-10-25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

3.0

QC5

INSPECT WORK TO CURRENT STEP



N/A

ml 07/09/19

Comment: INSPECT WORK TO CURRENT STEP

4.0

8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total: 21.0000 Each(s)
Insert M19493 X21
Batch M100775
A/R Hysol EA934NA
Expiry Date: 25 April 2007

See
Re-do the Step 4. NCR 085
New 21 inserts M15893
New Hysol M104835
exp. 12 MAY 2008
on new door

PTO

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).
2- Sand flush excess Hysol around the insert on both doors.

Re-do Step 5.
on new door
ml 07/09/25

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

ml 09.25 (1)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

ml 07/09/24

8.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

ml 07 09 25 (1)

9.0

D31101

ESCUTCHEON
D3110-1



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Handle
Batch 24673

✓

10.0

D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Handle
Batch B24694 B

✓

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/09/13	4	after the installation of 17 inserts 8000528 the door is no good cannot take out the inserts (door of serie 3) ml						
07/09/18	4	Because the first door Scrap. The 21 inserts 8000528 are Scrap too	ml 07/09/18	Replace the door NCR 085 Re-installs 21 ^{new} inserts	ml 07/09/18	ml 07/09/18	ml 07/09/18	ml 07/09/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SD Date: 07/10/25

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D3111041	Plate Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Plate Assembly

Batch M10S3617

✓

12.0	D31121	Guide
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch B27667

✓

13.0	D31131	Spring
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring

Batch B17437

✓

14.0	D31141	Pivot
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pivot

Batch B18630

✓

15.0	D31165	Seal 110-031-4
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Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s)

Seal 110-031-4

Batch B27208

16.0	D311611	SEAL
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Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)

SEAL

Batch B24675

~~B24675~~ B24675

17.0	D3119042	Cover Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

Batch B27725

W/O:		WORK ORDER CHANGES					
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

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Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	D31202	Cover, Flat Pattern
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover, Flat Pattern

Batch

B17416

19.0	D31204	Cover
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

B17424

20.0	D31251	Lever
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

M10536-17

21.0	D31253	Lever
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

M10536-17

22.0	D31255	Lever
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

M10536-17

23.0	D31257	Lever
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

M10536-17

24.0	D31291	Lever
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever

Batch

M10536-17

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Part Number: D41269404

Job Number:



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25.0	D31301	Clevis Base
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Clevis Base
Batch M10536-17 ✓

26.0	D31311	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Stop
Batch M10536-17 ✓

27.0	D31341	Rod
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rod
Batch B24681 ✓

28.0	D31344	Rod
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rod
Batch B18376 ✓

29.0	D314008	Door Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Door Kit
Batch B27446 ✓

30.0	D31431	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Clevis
Batch M10536-17 ✓

31.0	D31433	Clevis
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Clevis
M10536-17 ✓

W/O:		WORK ORDER CHANGES					
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Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D3144117

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch

B22022

33.0

D3144119

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch

B22023

34.0

D3144121

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch

B22024

35.0

D31452

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch

B26708

36.0

D31462

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hinge Bracket

Batch

B26710

37.0

D31471

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

Batch

M10536-17 x2

scrapped

D 3147-1

B30824

x2

Re-Pick Because upgrading.

38.0

D31491

Striker Plate




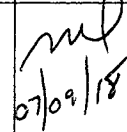
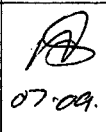


Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Striker Plate

Batch

M10536-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/09/18	37	take out two Pin D3147-1 Because last year the drawing was upgrade		Scrap 2 pin D3147-1 and replace by new one	 07/09/18	 07.09.18	 07.09.18	 07.09.18

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Job Number:



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39.0	D31501	Guide
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch M10536-17

✓

40.0	D31541	Key
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

Batch M10536-17

✓

41.0	D31571	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch M10536-17

✓

42.0	D3159041	Bracket Assembly
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch B18641

✓

43.0	D3159044	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch B24687

✓

44.0	AN52510R7	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch M15387

✓

45.0	AN960JD6L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch M5519

✓

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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46.0	AN960JD8	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer M11989 ✓

47.0	AN960JD8L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch M6956 ✓

48.0	AN960JD10	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer
Batch M100743 ✓

49.0	AN960JD10L	Washer
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Washer
Batch M16612 ✓

50.0	AN960JD10LL	Washer
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Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)
Washer
Batch M11763 ✓

51.0	ALS463280	Insert
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Insert
Batch M17841 ✓

52.0	BSP45	Commercial Rivet
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)
Commercial Rivet
Batch M11821

W/O:		WORK ORDER CHANGES					
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53.0	BSP46	Commercial rivet
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Commercial rivet

Batch

M109098

54.0	FW4032	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M11822

✓

55.0	FW10032	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

M11822 (2)

M19249 (14)

✓

56.0	M7885344	Rivets
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivets

Batch

M15659

✓

57.0	M7885345	Rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rivet

Batch

M1108

✓

58.0	MS203921C11	Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M18822

✓

59.0	MS203922C11	Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M14149

✓

W/O:		WORK ORDER CHANGES					
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60.0	MS203922C15	Pin
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

M 11796

✓

61.0	MS21042L3	Nut
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

15539

✓

62.0	MS21042L06	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

13166

✓

63.0	MS24665151	Cotter Pin
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Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

17566

✓

64.0	MS24694C4	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M 15924

✓

65.0	MS24694S53	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

M 15798

✓

66.0	MS24694S56	SCREW
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

14198

✓

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27446

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

67.0

MS24694S60

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

11766

✓

68.0

MS25281R6

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Batch

11759

✓

69.0

MS27039106

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

11754

✓

70.0

MS27039108

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

13356

✓

71.0

MS35206231

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M11735

✓

72.0

MS35650305T

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M11786

✓

73.0

MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

M11822

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 11:12:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27446

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
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74.0	NAS116910L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Batch 11753



75.0	NAS38868P	Screw
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Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Screw
Batch m19098

76.0	NAS391B6P	Washer
------	-----------	--------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Washer
Batch m19098

77.0	NAS43DD340	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spacer
Batch m11737

78.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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Comment: COMPOSITE ASSEMBLY
D412-694-04 Assembly Process
1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB).
Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod

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NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27446

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
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work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x 100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

9- Install (1) D3159-044 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.

Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.

Note: Position strike plate when big door is in locked position.

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).

Note: Install D3128-1 shim as required.

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-042 cover using drilling Jig D3119-042T1/T2 as per Dwg D412-694 page 3. Trim D3119-042 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

17- Install D3119-042 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

ml 07/10/09
ml 07/10/16

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Date: Wednesday, 6/7/2006 11:12:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27446

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

79.0

QC5

INSPECT WORK TO CURRENT STEP

79.A



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

07-10-10

80.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/10/17 ①

81.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/10/17 ①

Job Completion



07-10-16

79B: Put Red label inside before the cover. D3119-042 / OR VIP TRIM

07/10/16

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



Bordereau d'expédition Packing list

2699, 5e Avenue, local 14, C.P. 123, Grand-Mère (Québec) G9T 5K7
Bur. : (819) 533-5788 / Fax. : (819) 533-3494

DK - 0587

N° COMM. DU CLIENT CUSTOMER ORDER NO.		DATE D'EXPÉDITION DATE SHIPPED 23-OCT-06	EXPÉDIÉ PAR SHIPPED VIA DHA PPA	NOTRE N° OUR NO.	VENDEUR (EUSE) SALESPERSON
EXPÉDIER À: SHIP TO: DART AEROSPACE 1270 ABERDEEN STREET HAWBESBURY ONT K6A-1K7			VENDU À: SOLD TO:		
✓	QUANTITÉ / QUANTITY	CES / B.O	DESCRIPTION		
	1	—	D3140-08 REF, DELASTEK 25CD-0205 BEP. DART: B27446 CD412-694-04		
			SHIP. 23-OCT-06		
			L. J. Lucie		
BOITES CARTONS	POIDS TOTAL TOTAL WEIGHT	COMM. COMPLÉTÉE ORDER COMPLETE	RECTE DE COMM. À SUIVRE BALANCE TO FOLLOW	EMPAQUETÉ PAR PACKED BY	VÉRIFIÉ PAR CHECKED BY

VEUILLEZ NOUS AVERTIR DANS LES PLUS
BREFS DÉLAIS SI L'ENVOI EST INEXACT

PLEASE NOTIFY US IMMEDIATELY
IF ERROR IS FOUND IN SHIPMENT